

# Work Order ID 70520

Friday, June 10, 2011 2:52:19 PM



Page 1

Item ID: D2563

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

*P*

Date: 11-06-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2563

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Debur ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*AE 11.06.15*

*(x4)*

*11.06.17 (4)*

*AE 11.06.17*

*11.06.17 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				(+4)			
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				(x4)			
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				(Y)			

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Item ID:	D2563	Accept		Setup	Start	
Revision ID:						
Item Name:	Step Weldment Assembly				Stop	
Start Date:	6/10/2011	Start Qty:	4.00			
Required Date:	6/15/2011	Req'd Qty:	4.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>114703</u> Large Fab  Memo  1-Inspect for foreign object per QSI 024 2-Weld Remainig End cap as per Dwg D2563 using DT 8343 3-Grind	0.00  0.00				4	0		
160  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00							
170  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							

11.06.20  
J/AE 11.06.21

8 u 06/21

8 u 06/21

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 70520**

Friday, June 10, 2011 2:52:19 PM

Page 4

Item ID: D2563

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Revision ID:

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Start Date: 6/10/2011 Start Qty: 4.00

Required Date: 6/15/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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175 Pressure Wash per QSI005 4.3 0.00



HandFinish

Memo

0.00

Hand Finishing

Touch up Alodine as per QSI005

4X ~~Ø~~ M-L 11/06/22

180 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00



Powdercoat

Memo

0.00

Powder Coating

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:00

OVEN TEMPERATURE: 320 °F

FINISH TIME: 11:30

4X ~~Ø~~ M-L 11/06/22

190 Wing Walk as per dwg QSI005 4.4 Batch 0.00



HandFinish

Memo

0.00

Hand Finishing

116863.

4 BL 11-6-23.

M116964

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 0 11/06/23

210

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

PPP 70523

0.00

Packaging

Run/ps. 7 (4)

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/06/27

MF

11-06-27

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 10, 2011 2:52:25 PM

Page 1

Work Order ID: 70520

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 6/10/2011


Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2244-116  Step Extrusion		Manufactured	No			100	Each	127.0000	1	4			
---	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--


Location	Loc Qty	Loc Code
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HALL	93	
------	----	--

60307	93	
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WA	34	
----	----	--

60307	34	
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D2561  Lug		Manufactured	No			100	Each	19.0000	2	8			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA015	19	
-------	----	--

66813	5	
-------	---	--

68981	14	
-------	----	--

D2564  Mounting Angle		Manufactured	No			100	Each	36.0000	2	8			
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
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WA	36	
----	----	--

69286	36	
-------	----	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Friday, June 10, 2011 2:52:25 PM

Page 2

Work Order ID: 70520

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

D2673-34

Manufactured No

100 Each

103.0000

1 4



End Plate



*11-06-17*

Location

Loc Qty

Loc Code

WA

76

69534

76

WA015

27

59690

27

D2673-34

Manufactured No

150 Each

103.0000

1 4



End Plate



*4*

Location

Loc Qty

Loc Code

WA

76

69534

76

WA015

27

59690

27

*N*  
*A.*  
*double MF*  
*11-06-27*

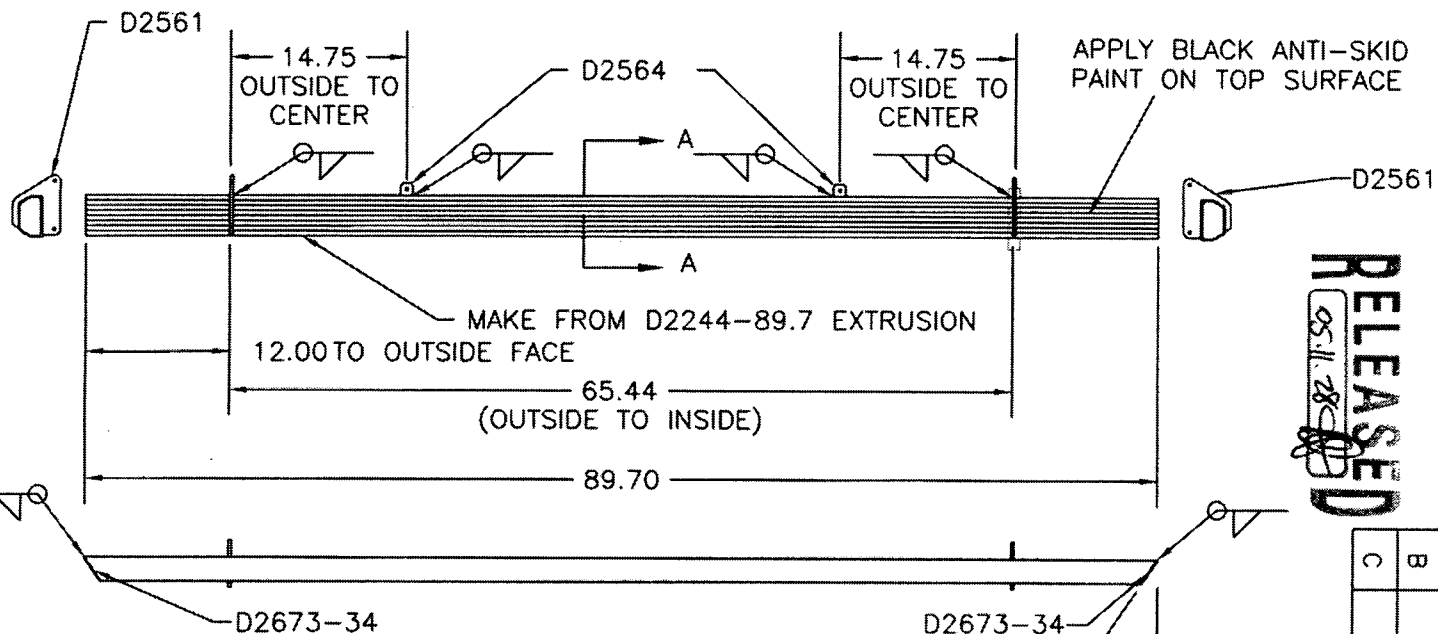
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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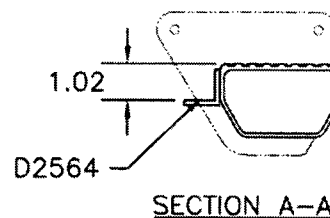
**NOTE:** Date & initial all entries



#### D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

\*cut per drawing



#### D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
05.11.28

**DART**  
TO COPY  
TO  
FOR  
UNCONTROLLED COPY  
SUBJECT AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70520

RL11-06-13

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2563
DATE 05.11.14		TITLE STEP WELDMENT ASSEMBLY
A	96.04.26	NEW ISSUE
B	97.05.14	END CAPS CHANGED (WAS D2248)
C	05.11.14	UPDATE NOTES
		SCALE 1:15
		SHEET 1 OF 1
		REV. C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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